

Work Order ID 64624 - 1

Thursday, December 09, 2010 12:41:51 PM

Page 1

Item ID: D350-588-011

Accept

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010 Start Qty: 10.00

Required Date: 12/10/2010 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan: *mf*

Date: *D-12-09*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

0.00

*Solo 12/14*

110

0.00



Packaging

Packaging

Pick Kit

Memo

0.00

*End 12/13*

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

*Solo 12/14*

*(x9)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64624**

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Accept

Revision ID:

Item Name: Aft Door Fwd Hinge Modification



Start Date: 12/10/2010 Start Qty: 10.00

Required Date: 12/10/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
	Memo Identify and pack for shipping as per PPP D350-588-011 Location: _____ PPP Rev: <u>0</u>	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

*12/14/14 (9)*

*10/12/14*

*MF*

*10-12-13*

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:M04.08.31 Added D2690-17 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7

Purchased

No

120

Each

132.0000

2

20



Screw

Location

Loc Qty

Loc Code

ST328

132

113064

1

113749

1

114056

30

116304

100

AN526C832R8

Purchased

No

120

Each

76.0000

8

80



Screw

Location

Loc Qty

Loc Code

ST327

76

114718

76

AN526C832R9

Purchased

No

120

Each

17.0000

8

80



Screw

Location

Loc Qty

Loc Code

ST327

17

115936

17

m114086

m116410 Bx

114718 Bx

6400 m114718

m115536 Bx

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Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD10 NAS1149D0363J Purchased

No

120

Each

8.0000

4

40



Washer



M118622

## Location

## Loc Qty

## Loc Code

ST

6

107715

6

ST335

2

105792

2

AN960JD8 NAS1149DN832J Purchased

No

120

Each

10.0000

24

240



Washer



M116391

## Location

## Loc Qty

## Loc Code

ST347

10

105059

10

D2143 Manufactured

No

120

Each

22.0000

1

10



Hinge Bracket



## Location

## Loc Qty

## Loc Code

ST198

22

55323

3

63595

19

D2144 Manufactured

No

120

Each

28.0000

1

10



Hinge Bracket



55323 14  
63595 94

12/14/10

## Location

## Loc Qty

## Loc Code

ST198

28

55179

28

55179

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2150  
Packer Doubler, Hinge

Manufactured No

120 Each

18.0000

2 20



64309 GP

## Location

## Loc Qty

## Loc Code

ST007

18

55178

6

63562

12

55178 2p  
63562 12

D2151  
Packer Doubler, Hinge

Manufactured No

120 Each

29.0000

2 20



64309 GP

## Location

## Loc Qty

## Loc Code

ST007

29

62246

29

62246

D2153  
Door Prop

Manufactured No

120 Each

7.0000

1 10



64311 SP

## Location

## Loc Qty

## Loc Code

ST272

7

59818

7

59818 SP

D2154  
Stud Bracket

Manufactured No

120 Each

66.0000

1 10



64312 SP

## Location

## Loc Qty

## Loc Code

ST007

66

55325

1

63597

15

64312

50

63597

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2237

Manufactured

No

120

Each

28,0000

2

20



Striker Plate

Location

Loc Qty

Loc Code

ST010

28

62212

28

62212

D2461

Manufactured

No

120

f

506.5000

7.25

76.31579



Neoprene "D" Seal

Location

Loc Qty

Loc Code

ST402

506.5000105

39782

6.5

55054

0.00001053

63880

500

63880

cut 1 X 87.00"

D2463

Manufactured

No

120

f

202.3205

7.25

76.31579



Seal

Location

Loc Qty

Loc Code

ST404

202.32053

55561

1.68

62597

200.64053

62597

cut 1 X 87.00"

Seal

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00



Manufactured No

120 Each

55.0000

2 20



*Handwritten signature*

## Location

## Loc Qty

## Loc Code

ST017

53

64080

22

64313

31

ST018

2

56527

2

*64080 184*

*64313 20*



Manufactured No

120 Each

30.0000

2 20



*Handwritten signature*

## Location

## Loc Qty

## Loc Code

ST018

30

62676

30

*62676*



Manufactured No

120 Each

25.0000

2 20



*Handwritten signature*

## Location

## Loc Qty

## Loc Code

ST204

25

61655

25

*61655 184*



Manufactured No

120 Each

3.0000

1 10



*64314 9x*

*12/12/14*

## Location

## Loc Qty

## Loc Code

ST019

3

56555

3

*56555 14*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2589 Manufactured No 120 Each 145.0000 1 10



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST019

145

58194

145

D2690-17



Cable

Manufactured No

120 Each

8.0000

1 10

Location

Loc Qty

Loc Code

ST021

8

62480

8

D2857-1



Hinge Bracket

Manufactured No

120 Each

16.0000

1 10

Location

Loc Qty

Loc Code

ST026

16

57924

16

D2857-2



Hinge Bracket

Manufactured No

120 Each

25.0000

1 10

Location

Loc Qty

Loc Code

ST027

25

55020

1

57925

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

S<sub>2</sub> D2858-1

Hinge Bracket

Manufactured No

120 Each

7.0000

1 10



63698

*[Signature]*

Location

Loc Qty

Loc Code

ST027

7

56423

1

61522

6

S<sub>2</sub> D2858-2

Hinge Bracket

Manufactured No

120 Each

0.0000

1 10



62020

*[Signature]*

FG-778150-550-ROL

Purchased No

120 sf

1,823.150

1 10



7781 9oz Glass 50"x125yd

*[Signature]*

Location

Loc Qty

Loc Code

ST404

1823.15

108932

18

111166

397

113905

1408.15

1- cut 1 square ft of glass cloth

MS20426AD3-4

Purchased No

120 Each

5,864.000

12 120



RIVET

m113905

*[Signature]*

Location

Loc Qty

Loc Code

ST316

5864

104374

1864

110398

4000

m104374

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W/O:		WORK ORDER CHANGES					
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Work Order ID: 64624

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-5

Purchased

No

120

Each

94.0000

18

180



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST309

94

114761

94

MS21042L08

Purchased

No

120

Each

370.0000

18

180



Nut

Location

Loc Qty

Loc Code

ST300

370

116082

22

116188

348

MS21042L3

Purchased

No

120

Each

1,211.0000

4

40



Nut

Location

Loc Qty

Loc Code

ST300

1211

114784

215

115835

996

MS27039-08-11

Purchased

No

120

Each

119.0000

2

20



Screw

Location

Loc Qty

Loc Code

ST288

19

114382

19

ST290

100

116289

100

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W/O:		WORK ORDER CHANGES					
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Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification



Start Date: 12/10/2010

Required Date: 12/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS27039-1-15

Purchased

No

120

Each

125,0000

2

20



Screw



12/10/13 (10)

Location

Loc Qty

Loc Code

ST292

125

114718

25

116169

100

114718 17x  
116169 3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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